106757



Page 1

September-11-13 11:	39:45 AM)*/					.: 		
Item ID: 646 Revision ID:			Accept	*N900	040	100)*	Setup Star Sto	1.71	S1*	-
Item Name: Strut Start Date: 9/23/ Required Date: 9/23/ Reference:	/13 Start Qty: 4.00	*4* *4*	-5*	Cust Item l Customer:	D:				* "N	S2*	
	cess Plan: MC5	Date: 13:09-	Tooling:		ate:	_	F	Run Sta	1/1	R1*	
QC		Date:		D:	ate:			Sto	*N	R2*	
Sequence ID/ Work Center ID	Operation Description	1.2	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr 646.3500	Revision Nbr	indi									
1.10	/ DAS 10 9-89		0.00				«	<u>ی</u>		Ac	
Waterjet FLOW CNC Waterjet	Memo 1-Cut 646. Dwg Rev:_ Prog Rev:_	3500 plate 2.75"x 1.50"	0.00 as per Dwg							13:11:	5 2
	2-Deburr if	necessary									
*120 *120*	QC2- Inspect parts off r	machine FAI/FAIB	0.00							1	1
QC Quality Control	Мето		0.00				 3	-		13.1	1-3

		•				•				DQA:	Dat	:e:
NCR: Y	es / No)			WORK ORDER NON-C	ONFO	RN	MANCE / UPDATE				
										QA Closed:	Dat	te:
Work Orde	ar.				DISPOSITION			AGAIN	IST DE	PARTMENT	/PROCESS	
WOIK Orde					Rework			Skid-tube Crosstu	ıbe	1	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small F	<u> </u>	Pro	d. Eng. Coor.	Quality
	•				Use-as-is	Th	erm	oforming Finish	ing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update			Large Fab Compos	site		Supplier	
Root				Descri	ption of work order update	Initia	1	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng	Description		Date	Verification	n QC Inspector
Doc/Data												
Equip/Tooling												
Operator						<u> </u>	İ					
Material					•		1					
Setup			İ									
Other												
Process						1						
Supplier							ı					
Training												
Unapproved										ļ		
						AULT CA	TEC	GORY				
Landi	ng Gear				General	_			_	7	,	 1
	Bendin	-		_	Bend	Gra	in		<u> </u>	Ovalized		Pressure/Forced
	_	Not Conce	ntric to	o/s	/S BOM/Route			re	L	Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged				Broken/Damaged	Insp	ecti	on Incomplete		Part Incorre	ct	Weld
	Crushe	L	Burrs			ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled		
	Cuffs Contamination					Ш Маі	inte	nance		Part Moved		
Heat Treat Countersink					Countersink	Misl	labe	led		Positioned V	Vrong	
	Inspec	tion Strip ir	Tube		Cut Too Short	Misi	read		L	Power Loss/	Surge	Other
	Rinnle	in Bend			Drill Holes	Offs	et					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-11-				*106	3757*						Page
Item ID: Revision ID: Item Name:	646.3511 Strut			Accept	*N900	<u>040</u>	100) *	Setup Star Stop	1.4	S1* S2*
Start Date: Required Dat Reference:	9/23/13 e: 9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process P QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Star Sto _l	"IV	R1* R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

Memo Quality Control

QC8- Inspect parts - second check

0.00

140 Small Fab 0.00 Memo

1- Fabricate tube as per dwg Small Fab

QC5- Inspect part completeness to step on W/O 0.00

150

0.00 Memo

(5) 13-11-19 9-89

Quality Control

130

140

150

130

13-11-19 MAL

Page 2

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	100	VFORN	ANCE / UP	DATE			
											QA Closed:	Date	•
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	٠ ِ No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			<u> </u>		Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					•					. ••			
						F	AUL	T CATE	GORY				
Landi	ng (Gear Bending				General Bend		Grain			Ovalized		Pressure/Forced
	一	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks			·	Broken/Damaged		Inspecti	on Incomplete	ļ	Part Incorre	ct	Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
1	Cuffs Contamination							Mainte	nance		Part Moved	_	_
	Heat Treat Countersink						Mislabe	led		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
		Ripples in	n Bend			Drill Holes		Offset			_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-11-1.				*106	\$757*							Page 3	3
Item ID: Revision ID: Item Name:	646.3511 Strut			Accept	*N900	040	100	ገ*	Setup	Start Stop		S1* S2*	<u> </u>
Start Date: Required Date: Reference:	9/23/13 9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:				2.			
Approvals: Sequence ID/		ın:	_ .	Tooling: SPC (Y/N):	Da	te: te:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 160 *160* Large Fab Large Fab	D	Weld per dwg A/R Ał Memo Weld tube	DAS 10 989 uminum rod Balch: M 16 to plate as per dwg. DT986 were tube is punch.	0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty	<i>'</i>	Reject Number	Insp. Stamp	m
170 *170* QC Quality Control		QC9- Inspect visual per	r QS1004- Fusion Welds	0.00					<u>) </u>	<u>3-11</u> . i	91	DAS 9 9-89	

180

QC5- Inspect part completeness to step on W/O

0.00

120

Memo

0.00

Quality Control

(B.11.21

D**as** 9 9-89

											DQA:	Date	2:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE	QA Closed:	Date	
	····					I		<u> </u>			- · ·		•
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	۔ ۔ No					Rework Scrap Use-as-is		ļ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	Τ	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш												
Material	Ш												
Setup	Ш				-								
Other	Ш		ł										
Process	Ш												
Supplier			ļ										
Training													
Unapproved													
							FAU	LT CATE	GORY				
Landi	ing G	Sear				General		_			_		_
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
}		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
Crushed/Crimped						Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Tre	at			Countersink		Mislabe	led		Positioned \	Vrong	
	Inspection Strip in Tube					Cut Too Short		Misread	I		Power Loss/	Sunge	Other
		Ripples ir	Bend			Drill Holes	Г	Offset			_	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-11-1				*106	3757*						Page 4
Item ID: Revision ID: Item Name:	646.351 Strut	1		Accept	*N900	040	100)* s	etup Star Stop	1 14	S1* S2*
Start Date: Required Date Reference:	9/23/13 : 9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process	s Plan:	Date:	Tooling:	Da	ate:	_	R	tun Star	1/1	R1*
			Date:	_ SPC (Y/N):	Da	ate:			Stop	` *N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 SprayPaint		Memo		0.00				_5_	_ø_	_Ø_	A8 13-12-7
Spray Painting		Prime as per Batch:	dwg (see note 3)								
230 * 2 20*		QC14- Inspect Spray Pai	nt	0.00				5			05/
* ? ? ? ? Quality Control		Memo		0.00							

***24**0*
Packaging

Packaging

0.00

0.00 Memo

IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV

5T523

5x = 5x = 13 - 12 - 99-89

					•				DQA:	Date:	•
NCR: Y	es / No			WORK ORDER NON	-CON	FORN	MANCE / UF		QA Closed:	Date:	
Work Orde	r:			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N				Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	In	itial	A	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chie	ef Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data								·		:	
quip/Tooling											
Operator									:		
Material											
Setup		1									
Other											
rocess							•				
Supplier											
Training											
Unapproved											
*					FAULT	CATE	GORY			· · · · · ·	

Landing	Gear	General			_		,
·' [Bending	Bend		Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	П	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped	Burrs	Г	Instructions Incomplete/Unclear	Part Lost/Missing	П	Wrong Stock Pulled
	Cuffs	Contamination	Γ	Maintenance	Part Moved		
	Heat Treat	Countersink		Mislabeled	Positioned Wrong		
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset	•		· · · · · · · · · · · · · · · · · · ·
	Torque Waves in Extrusion	Drawing	Г	Out of Calibration			
	Turning Sequence	Finish	Г	Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 106757 *106757* Page 5 September-11-13 11:39:45 AM *N900040100* Item ID: 646.3511 Accept Setup Start **Revision ID:** Stop Strut Item Name: *4* Start Date: 9/23/13 Start Oty: 4.00 **Cust Item ID:** Required Date: 9/23/13 **Req'd Qty:** 4.00 *4* **Customer:** Reference: Run Start **Tooling:** Process Plan: ____ Date: ____ * Approvals: Date: Stop Date: SPC (Y/N): QC: ___ Date: Tool ID Sequence ID/ Operation Set Up/ Tool # Plan Accept Reject Reject Insp. Code Number Stamp Work Center ID Description **Run Hours Qty** Qty 0.00 250 QC21- Final Inspection - Work Order Release *250* 0.00 Memo Quality Control

M D

Ch

							-					DQA:	Date	<u>:</u> :	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE		-			
									•		Q	A Closed:	Date) :	
Work Ord	er:					DISPOSITION				AGAINST D	EP/	ARTMENT/	PROCESS		
						Rework	1		Skid-tube	Crosstube	٦		Water Jet	7	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	┪.	Proc	d. Eng. Coor.	7	Quality
	•					Use-as-is	1		noforming	Finishing			e/Packaging	7	Other
NCR I	No.					Work Order Update]		Large Fab	Composite]		Supplier]	
Root					1	ption of work order update		Initial		ction		Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	ription	_	Date	Verification	\bot	QC Inspector
Doc/Data	Ш											İ			
Equip/Tooling					ŧ.		1		ļ						
Operator	Ш														
Material	Ш														
Setup	Щ]										
Other	$oxed{\Box}$														
Process							1								
Supplier			1	ļ			1								
Training															
Unapproved					<u> </u>							<u></u>		$oldsymbol{\perp}$	
						F	AUI	LT CATE	GORY						
Landi	ing (Gear				General		_		_			_		
		Bending				Bend		Grain			_]o	valized		P	Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	are		o	ver/Under	tolerance	T	emperature/Cure
						Broken/Damaged		Inspect	ion Incomplete		P	art Incorrec	t [\neg v	Veld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

September-11-13 11:39:44 AM

Work Order ID:

106757

Parent Item:

646.3511

Parent Item Name:

Strut

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP REV:A 12.10	.19 NEW ISSUE	DD VE	KF:JLM 									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet 063		Purchased	No				sf	205.8000		0.1170528		4u	13.11
				Location		Loc Qty	Lo	c Code					
				MAT020		205.7999998							
4				123	136	140.8							
. 1				M1	26159	65			12	16159		, 1	>
M304TR0.500W.049		Purchased	No				f	359.9887	U	3.5073684			
04 RD Tube .500 x .049\	N												
,				Location		Loc Oty	Lo	oc Code					
,				GA		43.66							
,				120	1633	43.66							
				MAT017		316.328716							
				119	087	0.000016							
				123	449	86.0547							
t }				125	513	30.274					_		
				mil	26466	57 200					3-11-	-20	MI

NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORN	MANCE / UPC	DATE				
						- -					QA Closed:	Da	te:	
Work Ord	er:					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS		
Part I	•					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor, re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Descri	iption	Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling													1	
Operator													1	
Material													1	
Setup			٠											
Other														
Process					İ		İ						1	
Supplier													1	
Training														•
Unapproved						·								
							FAU	LT CATE	GORY					
Landi	ng (Sear				General		_						
		Bending				Bend	L	Grain			Ovalized			Pressure/Forced
	L	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	\square	Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	\square	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved			
	Heat Treat					Countersink		Mislabe	led		Positioned V	Vrong		
	Inspection Strip in Tube					Cut Too Short	Г	Misread	ł		Power Loss/	Surge		Other
	Ripples in Bend					Drill Holes		Offset		<u> </u>			····	
	Ripples in Bend Torque Waves in Extrusion					Drawing		Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 106 757
Description:	Part Number:
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing			Drawing Actual Actual Method of								
Dimension	Tolerance		Dimension	Accept	Reject	Inspection	Comments				
2.75" 1.50" 1063"	+/~	(to 3 to	2.75	_		V	JKm-01				
1.50"	*11	, 030	1,50"	1		V					
1063"	+1/	(010	1059			U					
<u> </u>					 						
						J					
				·							
ĺ	1		l								

Measured by:	Audited by:	DAS 27	Preliminary Approval:	
Date: /3/// ひみ	Date:	R 11 04	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

APICAL INDUSTRIES, INC. TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	ENGINEERING CHANGE DWG NO. 646.3500 R DWG TITLE: APPROVED BY: ENGR TSTATE REASON: REVISED GEOMETRY	REVINC PREPARED S.	P QC (4	EFFI CURRENT ORDER AND STOCK
SHEET 2 IS:	130		646.3 646.35	512 SHOWN 13 OPPOSITE
(8.25)	7.60 7.60 7.60 7.60 7.60 7.60 7.60 7.60 7.60 7.60 7.60	200	20	106757 MUT 13-09-16
DOCUMENTS EFFECTED	☐ MDL ☐ INSTALL INSTRUC	☐ ICA ☐ FMS ☐ BOM	CHANGE CATEGORY DE	R REVIEW REQUIRED

• • x

^**	ENGINEERING CHANGE NOTICE NO. 0219	1
APICAL	DWG NO. 646,3500 REV:N/C BY S. HUFF	DATE: 01/05/09 EFFECT ON DWG
INDUSTRIES, INC.	DWG TITLE: STRUT	
	APPROVED BY ENGR Bran MFG QC	EFF: NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED ANGLE OF 646.3512 & 646.3513 FOR E	BETTER PITMENT
SHEET 2, IS	72 385' 7.15 385' 7.15 200 200 200 200 CHANGE	CATEGORY DER REVIEW REQUIRED
	· □MDL □ INSTALL INSTRUC □ ICA □ FMS □ B□M □ MAJ□R	R MINOR YES MINOR

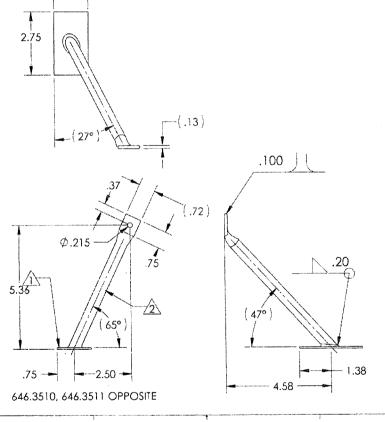
NOTES:

MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11; .062" THK.

MATERIAL: 6061-T6 ALUMINUM IAW AMS-WW-T-700/6 .500" OD; .062" WALL THK

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2 COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N

- 4. DEBURR AND BREAK ALL SHARP EDGES
- WELDS IAW MIL-STD-2219. TIG WELD WITH FILLER ROD



1.50

646.3510 SHOWN 646.3511 OPPOSITE

UNINCORPORATED ECN(s)

02197, 02440.

		9:46 Disti	SE OTHERWISE SPICES PESONS AIR OF FICHE SEARCES ARE	io mete	AGE CODE: 1744	STRUT 646.350	l av
646.40	XIU	35 23	SECTION C	3 - 6	EANSIDE. (CA. 92056-3512	(760)724-530
			SERSTON P. BRAND	260	IS TEMPLE I	EIGHTS DR.	
NEXT A	f2) Y22	DRAD!	MALEJATI DA YP) 06-23-08	_ /	APICA	L INDUS	STRIES
QIY				PART			
	FIN	D #	PART#	DES	CRIPTION	MATL	SPEC.
			646.3510	STRUI			
			646.3511	STRUT			
			646.3512	STRUT			<i>₫</i>
1 i	1		646.3513	STRUT			<u> </u>

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Linda Lacelle

From:

Pablo Bravo

Sent:

September-13-13 12:11 PM

To:

Jean-Luc Menard

Cc:

Linda Lacelle

Subject:

Re: STRUTS 646.3500

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Go ahead and manufacture the parts you need to replenish stock. I'll try to get a date for the drawing release ASAP.

Pablo

On Sep 13, 2013, at 8:31 AM, "Jean-Luc Menard" < imenard@dartaero.com > wrote:

Hi Pablo,

As discussed yesterday, dwg's are under review.

Just need your blessing so we can manufacture to meet current orders.

THX

JL

Jean-Luc Ménard

Production Engineering Supervisor

DART AEROSPACE

T 1 613 632-5200 > 227

F 1 613 632-5246

1 800 556- 4166

www.dartaerospace.com

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